



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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split

D3204-041
Job Sheet 192605-A



Part No: D3204-041

Job Qty: 4 pcs

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/30/19

Job Tracking No:

Due Date: 4/18/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
150	QC 3	4 pcs	4/18/19	4/18/19	0.00	0.00	QC 3 - 10		
160	Small Fab - 2 - B4B	4 pcs	4/18/19	4/18/19	0.00	0.27	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		DAS 58 MAY 06 2019 9-89
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
170	QC 5	4 pcs	4/18/19	4/18/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		DAS MAY 07 2019 40 9-89
180	Packaging 3-1 - Stock - B4B	4 pcs	4/18/19	4/18/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

	Packaging 3 - 7 - B4B		
	Packaging 3 - 8 - B4B		
	Packaging 3 - 9 - B4B		
	Packaging 3 - 10 - B4B		
	Packaging 3 - 11 - B4B		
	Packaging 3 - 12 - B4B		
	Packaging 3 - 13 - B4B		
	Packaging 3 - 14 - B4B		
	Packaging 3 - 15 - B4B		
	Packaging 3 - 16 - B4B		
	Packaging 3 - 17 - B4B		
	Packaging 3 - 18 - B4B		
	Packaging 3 - 19 - B4B		
	Packaging 3 - 20 - B4B		
	Packaging 3 - 21 - B4B		
	Packaging 3 - 22 - B4B		
	Packaging 3 - 23 - B4B		
	Packaging 3 - 24 - B4B		
	Packaging 3 - 25 - B4B		
	Packaging 3 - 26 - B4B		
	Packaging 3 - 27 - B4B	GA119 ST MAY 07 2019	
	Packaging 3 - 28 - B4B		
	Packaging 3 - 29 - B4B		
	Packaging 3 - 30 - B4B		
	Packaging 3 - 31 - B4B		
	Packaging 3 - 32 - B4B		
	Packaging 3 - 33 - B4B		
	Packaging 3 - 34 - B4B		
	Packaging 3 - 35 - B4B		
	Packaging 3 - 36 - B4B		
	190 QC 21 - SA	4 pcs	4/18/19 0.00 0.00
			QC 21 - SA - 21
			QC 21 - SA - 70
			QC 21 - SA - 53
	Part Op 150 - (QC3- Inspect Part Finish) Descriptions: 160 - (Small Fab) 170 - (QC5- Inspect part completeness to step on W/O) 180 - (Identify as per dwg & Stock Location: _____) LOCATION : GA 190 - (QC21- Final Inspection - Work Order Release)		

DAS
21
9-89
MAY 07 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3204-7	Bushing	8 pcs (2 ea)	160-Small Fab - 2 - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
160-Small Fab - 2 - B4B	D3204-7	8	8	0

Part Specifications	
Specifications could not be found.	



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D3204-041
Job Sheet 192605



split 4

Part No: D3204-041

Job Qty: 1 pcs

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/28/19

Job Tracking No:

Due Date: 4/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	4/18/19		0.00	1.30	Large Fab - 1		<i>EL</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	1 pcs	4/18/19		0.00	0.00	QC 9 - 10		APR 29 2019
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	4/18/19		0.00	0.00	QC 5 - 10		APR 29 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



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CANADA
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Container No: S175714



Part: D3204-041

Job No: 192605

Serial No/Batch: S175714

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/26/19

Plex 3/28/19 10:24 AM Dart.lajeunesse.marie

				QC 5 - 30	
				QC 5 - 40	
130 Handfinish - 1-1 Chemical- B4B	1	4/18/19	0.00 0.09	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/04/29
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 Powdercoat - 3 Grey Sand - B4B	1	4/18/19	0.00 0.07	Powdercoat - 1 - B4B	
	pcs			Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
150 QC 3	1	4/18/19	0.00 0.00	QC 3 - 10	
	pcs			QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	DAS
				QC 3 - 58	58 APR 19 2019
				QC 3 - 59	9-89
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
160 Small Fab - 2 - B4B	1	4/18/19	0.00 0.07	Small Fab - 1 - B4B	DAS
	pcs				58 APR 19 2019
					9-89

					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
170 QC 5	1 pcs	4/18/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
180 Packaging 3-1 - Stock - B4B	1 pcs	4/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
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					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
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					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

190 QC 21 - SA

1
pcs

4/18/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - (Fabricate per Drwg) 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding. 2- Place parts
Descriptions: D3204-1,3,5,13 in jig number DT10295 for tacking parts together.3- Remove part from jig and install spacing rods to 6"
inside of D3204-3 and D3204-5; weld parts then after parts have cooled; remove spacing rods...4- Inside measurement
should be @ 5.9". Then proceed to installing D3204-11 plate, then D3204-9 pedal.5- Fill #30 hole when parts are cooled
to room temperature quickly at around 150 amps...

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Chemical Conversion Coat per QSI005 4.1)

140 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE:

FINISH TIME:

150 - (QC3- Inspect Part Finish)

160 - (Small Fab)

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____) LOCATION : GA

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

009455

Part / Item	Component Name	Quantity	Operation	Container
D3204-1	Tube	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5097143
D3204-11	Plate	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5173550
D3204-13	Gusset	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5120389
D3204-3	Arm	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5173655
D3204-5	Arm	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5089779
D3204-9	Pedal	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5173681
D3204-7	Bushing	2 pcs (2 ea)	160-Small Fab - 2 - B4B	5137715

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D3204-1	1	10	0
	D3204-11	1	3	0
	D3204-13	2	16	0
	D3204-3	1	2	0
	D3204-5	1	4	0
	D3204-9	1	2	0
	D3204-7	2	12	0
160-Small Fab - 2 - B4B				

Part Specifications

Specifications could not be found.

Plex 3/28/19 10:24 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



AEROSPACE

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Container No: S176331

Part: D3204-041

Job No: 192605-A

Serial No/Batch: S175714

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/06/19